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□ (16) (01) (02)
* (01)
+ (01)
X (16)

07

40

TRIM/REDUCE MESH PROFILE TO
MATCH STIFFENER PLATES
(SEE NOTE 6)

16

21

□ (24) (25) (02) (01) (16)
* (01)
+ (01)
X (24) (25)

26

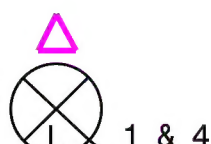
4x1

□ (16) (01) (02) (24) (25)
* (01)
+ (01)
X (16)

20

□ (02) (01) (16)
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+ (01)
X (02)

PART MARK
TO QD5016



ASSY PART No.: QB21308
ISS No.: '*'
BATCH No.: '**'

FLOW



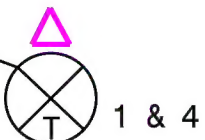
EXPLODED VIEW
N.T.S.

REF	PART NUMBER	PER ASSY	DESCRIPTION	MATERIAL/REMARKS
01	QB21817	1	MESH SCREEN	---
02	QB21487	1	STIFFENER PLATE	---
03	QB21496	1	RECEPTACLE	---
04	QD3072-46	4	DFCI RECEPTACLE	1219-PSP4-2-Z3CT
05	QD3072-47	4	DFCI STUD	121J-W470-SE-Z3CT
06	QD3072-48	4	DCFI GROMMET	127H-4
07	SP87-403-5	40	RIVET CSK HD	MONEL
08	---	---	---	---
09	QD3088-133	A/R	PRIMER EPOXY PR143	---
10	QD3088-134	A/R	CATALYST 143	---
11	QD3088-135	A/R	THINNERS T17	---
12	QD3088-43	A/R	FINISH: SATINE GREY	R36665 / 98A / 3
13	QD3088-44	A/R	HARDENER J9812	---
14	QD3088-73	A/R	THINNERS A983	---
15	QD3066	A/R	DURALAC	---
16	QB21495	1	STIFFENER PLATE	---
17	---	---	---	---
18	---	---	---	---
19	---	---	---	---
20	SP81-403-5	17	RIVET SNP HD	MONEL
21	SP81-405	16	RIVET SNP HD	MONEL
22	SP71-505	8	RIVET CSK HD	---
23	QD3084	A/R	750C SEALANT	---
24	QB21820	2	STIFFENER	---
25	QB21828	2	STIFFENER	---
26	SP87-404	4	RVT CSK HD	MONEL

ISOMETRIC VIEW
N.T.S.

A - SEE SHEET B

PART MARK
TO QD5016



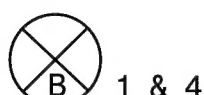
ASSY PART No.: QB21308
ISS No.: '*'
BATCH No.: '**'



□ RIVET TOGETHER ()
* SPOT THRO' REF ()
+ OPEN OUT HOLE IN REF ()
X HEAD ADJACENT TO REF ()
X CSK ADJACENT TO REF ()

NOTES:

1. FINISH: PRIOR TO ASSEMBLY, ENSURE REF 03 HAS BEEN PRIMED AND FINISH PAINTED USING REFS 09-14 IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS.
2. MESH (REF 01) TO BE LOCALLY DEFORMED TO CLEAR RIVETS AND DZUS PIN (REF 05) PRIOR TO FINAL ASSEMBLY. **DO NOT DRILL.**
3. ASSEMBLE REFS 01, 02, 05, 06 AND 16 USING TOOL 9906-RS-35 AND BLOCK 9902-1-135.
4. WET ASSEMBLE REFS 03 AND 04 USING DURALAC (REF 15).
5. RIVET HOLES TO QD1028. RIVET TO QD5104.
6. TRIM MESH, REF 01, TO PROFILE OF STIFFENER PLATES REF 02 & 16. MESH OUTER PROFILE MAY BE LASER CUT.
7. REMOVE ALL SHARP EDGES. ENSURE ANY EDGES THAT CONTACT MESH REF 01 ARE SUITABLY DEBURRED.
8. APPLY SEALANT REF 23 TO SURFACES OF REFS 02 & 16 THAT ARE IN CONTACT WITH MESH REF 01. REMOVE EXUDED EXCESS.

PART MARK
TO QD5016



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	DECIMALS	ANGLES			DRG BY	T SMITH	18 FEB 2013					
	.X ± 1.0	± 0.5 DEG			DRG CHK	T CLARK	25 APR 2013					
	.XX ± 0.5				PROJ ENGR							
	.XX ± 0.25		APPLICATION		MFG ENGR		TITLE ASSEMBLY SCREEN	SIZE A1	CAGE CODE U0088	DRG NO QB21308	ISS 2AY	
	.XXX ± -		NEXT ASSY	TECH APRL								
	SURFACE FINISH	3.2	DSGN APRL									
	DO NOT SCALE DRAWING		DSGN APRL	D P SMITH	26 APR 2013							
			USED ON QB05008		CONTRACT NO		SCALE 1:2		WEIGHT		SHEET A OF B	

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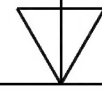
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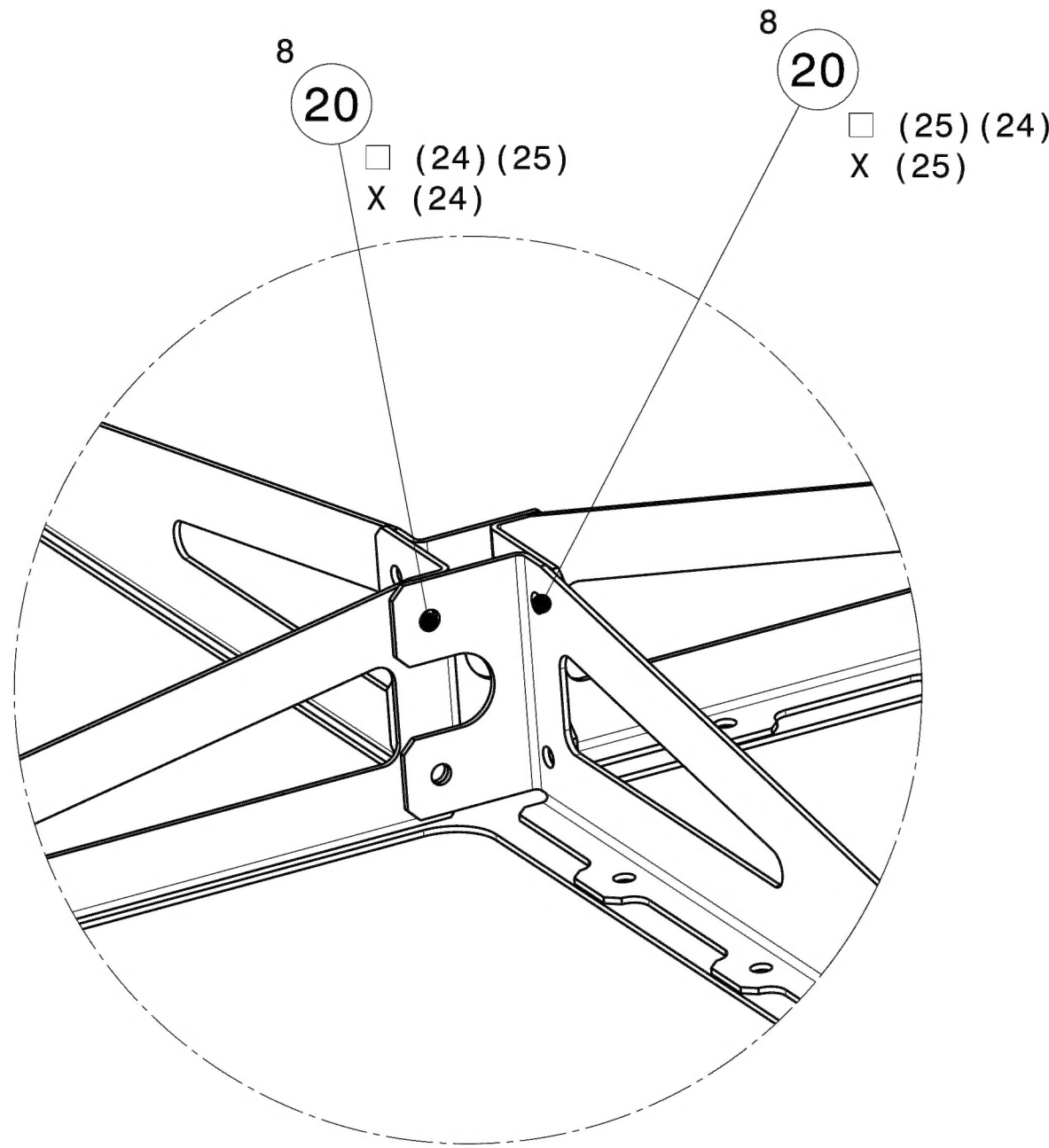
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DRG NO	QB21308	SH	ISS
		B	B
			2AY

1

ZONE	ISS	DESCRIPTION	DATE		APPROVALS
D7	2AY	ADDED LASER ETCH AND INK MARK ECR R38887 INCORPORATED	6 MAR 2014	MODIFIED	B MITCHEM
		CHANGE CODE: OR	6 MAR 2014	DRG CHCK:	T CLARK
				PROJ ENGR:	
				MFG ENGR:	
				TECH APRL:	
			13 MAR 2014	DSGN APRL:	D P SMITH



DETAIL A
SCALE: 1:1

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	TOLERANCES ARE:				DRAWN BY	T SMITH	18 FEB 2013							
	DECIMALS				DRG CHCK	T CLARK	25 APR 2013							
	ANGLES				PROJ ENGR									
	NEXT ASSY				MFG ENGR									
	X. ± 1.0		± 0.5 DEG		APPLICATION		TECH APRL		SIZE A1.	CAGE CODE U0088	DRG NO QB21308	ISS 2AY		
	.X ± 0.5				USED ON		DSGN APRL							
	.XX ± 0.25				QB05008		DSGN APRL	D P SMITH	26 APR 2013				CONTRACT NO	
	.XXX ± -													
	SURFACE FINISH		3.2						SCALE 1:2		WEIGHT		SHEET B OF B	
DO NOT SCALE DRAWING														

12

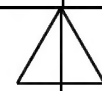
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